

5/23

DART AEROSPACE LTD	Work Order:	23410
Description: Bushing	Part Number:	D2617-7
Dwg: D2617 Rev. E	Qty:	24

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JG	05.05.20	20
2	MC	Machine as per Folio FA454 and Dwg D2617 Material: Delrin Round Bar Ø0.500" (M-DELRIN-R0.500) Identify as D2617-7	J.G	05/05/20	20
3	QC2	Inspect parts as they come off the CNC machine	J.G	05/05/20	20
4	QC8	Second check	JG	05.05.20	20
5	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	J.G	05/05/20	20
6	QC5	Inspect work to Step 5	J	05.05.20	21
7	ST	Identify and Stock	JL	05/05/20	21
8	AC	Cost / part: 2.03	Sut	05-06-01	21
9	DC	Close W/O 2.03 Inspect Level 21	JG	05/06/20	21

Rev	Date	Change	Revised By	Approved
A	04.08.25	New Issue	KJ/JLM	JG

RELEASED
04/08/2023

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

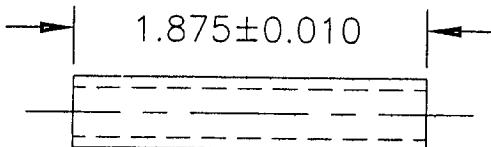


DESIGN	BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED #	DRAWING NO. D2617
DATE	01.07.04	TITLE	SCALE 1:1
		BUSHING	

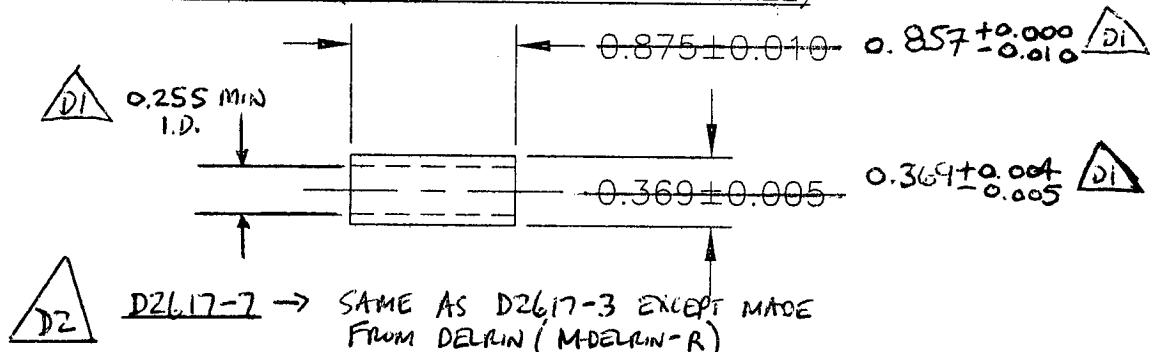
D2 | 04.09.10 #/P ADD D2617-7

A	96.10.08	NEW ISSUE
B	97.05.08	.875 WAS 1.125
C	97.06.04	0.369 DIA WAS 0.375
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
DI	CP # 04.07.12	CORRECT TOLERANCE (NCR 779)

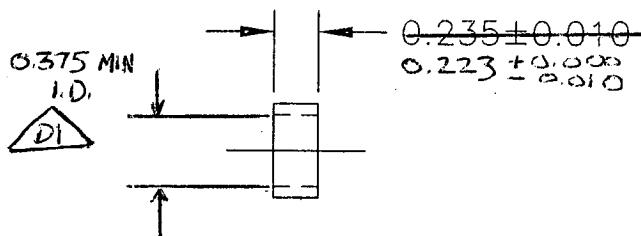
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05 #/P

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RETURN TO
ENG. INNEERING

CONTROLLED COPY

CT TO AMENDMENT
THOUT NOTICE

WORK ORDER

NO. 23410

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 20, 2005
01:40 pm

Work Order No	:	0023410	Department Code:
Project Name	:	D2617-7	Burden Flags : NNNNNNNN
Project For	:	WK523	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D2617-7	Invoice Number :
Description	:	Bushing	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	20	Order Entry No :
Amount Done	:	0	OE Value : 0.00
Start Date	:	05-20-05	
Est Finish Date	:	06-05-05	Est Mark Up : 0.000%
Act Finish Date	:		Actual Mark Up : 0.000%
Drawings Reqd	:	No	
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00

DART AEROSPACE LTD	Work Order:	23410
Description:	Part Number:	2617-7
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>J.G</u>	Audited by:	<u>R</u>	Prototype Approval:	<u>N/A</u>
Date:	<u>05/05/25</u>	Date:	<u>05.05.26</u>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	